

Date: Friday, 6/16/2006 1:46:24 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLEVIS
Job Number : 27560	
Estimate Number : 10651	
P.O. Number : N/A	Part Number : D2748
This Issue : 6/16/2006 S.O. No. : N/A	Drawing Number : D2748 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 6/15/2006 Type : PURCHASED PARTS	Drawing Revision : A
Previous Run :	Material : N/A
Written By : <u>See comment below</u>	Due Date : 7/20/2006
Checked & Approved By : <u>[Signature]</u>	Qty: 20 Um: Each
Comment : Est. B99.10.27 Now laser cutting EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S16GA	304/316 .063 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.0145 sf(s)/Unit Total : 0.2900 sf(s)
 304/316 .063 Sheet

Batch: M7106

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------

**Comment:** FLOW WATER JET

SAD

06:06:19

20

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

SAD

06:06:19

20

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

[Signature] 06.06.22

20

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr any rough edges after tumbling
 Bend as per Dwg D2748 using bending jig DT 8289

FF 06.06.26

20

6.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------

**Comment:** INSPECT WORK TO CURRENT STEP

SB 06/06/27

20

Date: Friday, 6/16/2006 1:46:24 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 27560

Part Number: D2748

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5759

Rec'd 6/28 (20)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

20
27 06/06/28

Job Completion



W 06/06/28

Date: Thursday, 6/15/2006 1:41:35 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CLEVIS
Job Number :	27560		
Estimate Number :	10651		
P.O. Number :		Part Number :	D2748
This Issue :	6/15/2006	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2748 REV A
First Issue :	/ /	Project Number :	N/A
Previous Run :		Drawing Revision :	A
	Type :	Material :	
	PURCHASED PARTS	Due Date :	7/20/2006
Written By :		Qty:	20
Checked & Approved By :	<i>[Signature]</i>	Um:	Each
Comment :	Est. B99.10.27 Now laser cutting EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------



Material
M304503
(.0145 SF)



Comment: PURCHASING

Issue P/O:

Laser Cut per Dwg D2748

Material release note required

Batch:

2.0	D2748F	Clevis
-----	--------	--------

*Dwg Rev:*

Comment: Qty: 1.0000 Each(s)/Unit Total 20.0000 Each(s)
 Clevis

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

QC2

Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC8	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------




Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr any rough edges after tumbling

Bend as per Dwg D2748 using bending jig DT 8289

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 06/06/20

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 27560

Part Number: D2748

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

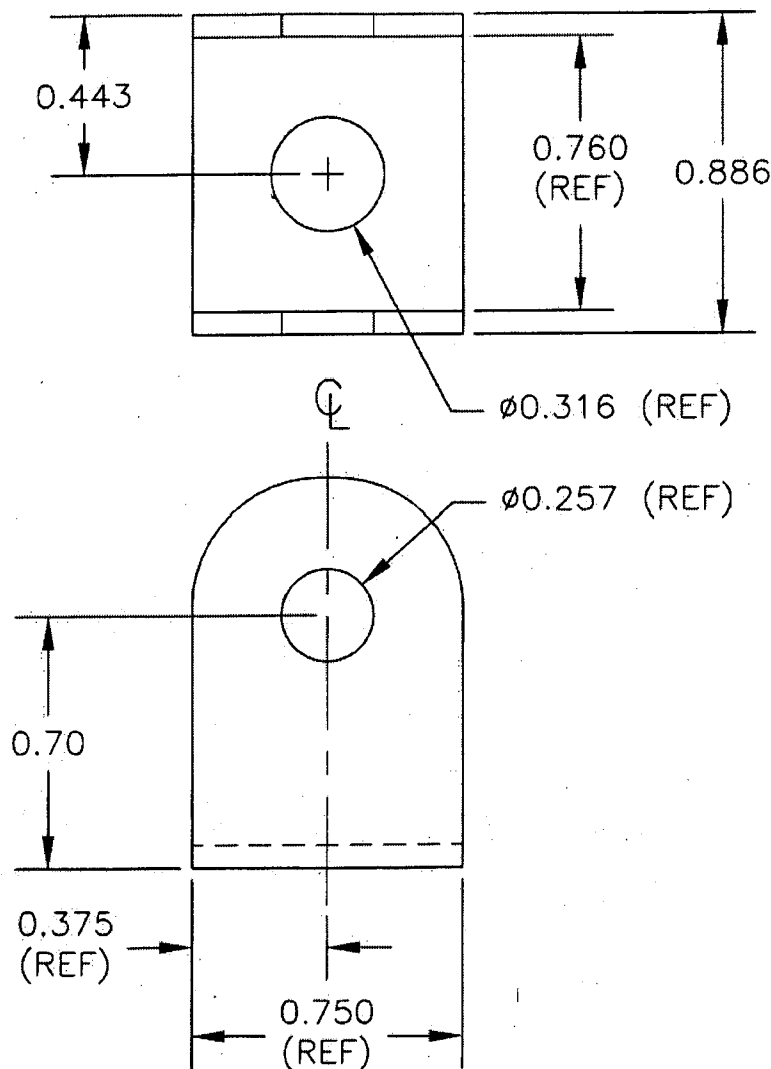
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>TH</i>	APPROVED <i>CL</i>	DRAWING NO. D2748	REV. A SHEET 1 OF 2
DATE 99.09.24		TITLE CLEVIS	SCALE 2:1
A	99.09.24	NEW ISSUE	

RELEASED
99.10.12 KE



MATERIAL: AISI 304/316 SS 0.063 THICK

USE 0.125 BEND RADIUS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

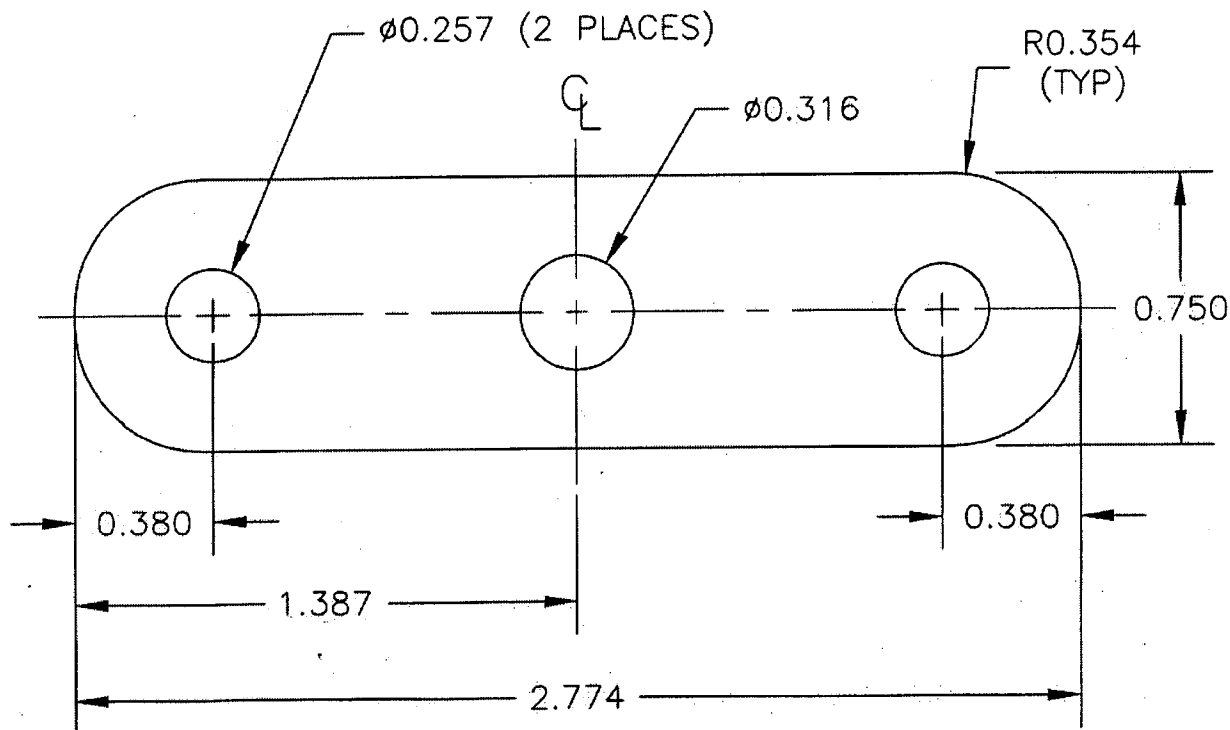
WORK ORDER

NO. 27560



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2748	REV. A SHEET 2 OF 2
DATE 99.09.24		TITLE CLEVIS	SCALE 2:1

RELEASED
99.10.12 KE



D2748 FLAT PATTERN

MATERIAL: AISI 304/316 SS 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27560

